



Date: Thursday, 15/03/2007 10:53:51 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACKING PLATE
Job Number : 31237	
Estimate Number : 10506	
P.O. Number : N/A	Part Number : D2228
This Issue : 15/03/2007 S.O. No. : N/A	Drawing Number : D2228 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31157	Material : N/A
Written By : 	Due Date : 22/03/2007
Checked & Approved By : 	Qty: 15 10 Um: Each
Comment : Est:B 00.08.22 Re-format EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M5052H32S063	5052-H32 .063 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0227 sf(s)/Unit Total : 0.2270 sf(s) *X16 (0.3632) sf*
 5052-H32 .063 Sheet
 Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick
 (M5052H32S.063) Batch: *M19296* *ml 07/03/15*

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut blank: 1.710" x 1.920" *ml 07/03/15*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr - *Holes as per drawing* *ml 07/03/15*

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP *SB 07/03/15*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *M-H* *07/03/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/03/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/03/2007 10:53:51 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKING PLATE

Job Number: 31237

Part Number: D2228

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M103706



15x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/03/16

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SPB

07/03/16

16

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SPB

07/03/16

16

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SPB

07/03/19

16

Job Completion



U 07.03.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

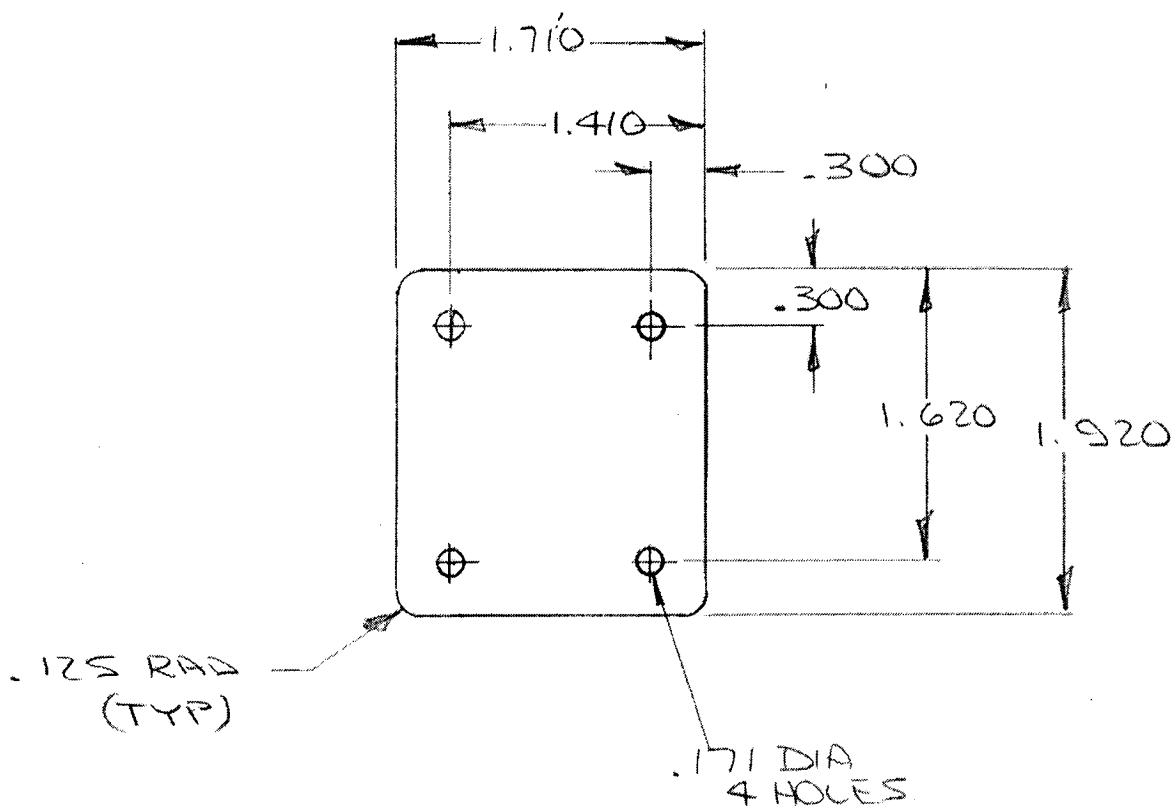
NOTE: Date & initial all entries

DART



DRAWN BRADLEY 94.2.23	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.2.23	DRAWING NO. D2228	REV. B
STRESS	TITLE BACKING PLATE	
B	00.09.11	UPDATE FINISH SPEC. # UP

RELEASED
00 09 12 #



MATERIAL: 5052-H32 .063 THICK
(QQ-A-250/8)

FINISH :  CHEMICAL CONVERSION COAT PER DART QSI QOS 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI QOS 4.3

W/O 31237

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries